

Work Order ID 69475



Page 1

Wednesday, May 11, 2011 11:51:40 AM

Item ID: D4164-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Adapter Assembly

Start Date: 5/11/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

11

Date:

11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4164

A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

*B 11-5-18**60*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-5-18

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*5 11-5-18**Counter*
x60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4164-041

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

1- Deburr
2-C'sink as per Dwg

140



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

141



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Hand Finishing

5/14/05/18 (60)
Pho →

counts
(59) (60)

59X M/L 11/05/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4164-041 PAR #: N/A Fault Category: Small FAB NCR: (Yes) No DQA: 11 Date: 11.06.02
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/06/03 Date: 11/06/03

NCR: 69475		WORK ORDER NON-CONFORMANCE (NCR) #4.31						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/19	#130	Found qty x1 part that was not deburred correctly. The water jet tape was removing unevenly. R.L. Lack of Attention. Darryl	11.05.18 CS1042	→ Scrap + Destroy No replace extra made.	11/06/01	S 11/05/19	11.05.18 CS1042	11/05/19
		Deburr:						

NOTE: Date & initial all entries

Work Order ID 69475

Wednesday, May 11, 2011 11:51:40 AM



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Item ID:	D4164-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Nut Plate Adapter Assembly					
Start Date:	5/11/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	5/18/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				59		BR 11-5-24.	
170 Small Fab Small Fab	Small Fab Memo Install Nut plate as per Dwg	0.00 0.00						EF 11/06/01 (59)	
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						Winters (759)	

Sublog 107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 69475

Wednesday, May 11, 2011 11:51:40 AM

Page 4

Item ID: D4164-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Nut Plate Adapter Assembly
Start Date: 5/11/2011 Start Qty: 20.00  Cust Item ID:
Required Date: 5/18/2011 Req'd Qty: 20.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Packaging	Identify as per dwg & Stock Location: <u>135</u> Memo	0.00 0.00							<u>11/21/11</u> <u>SP</u> <u>(59)</u>
200  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/6/2011</u> <u>mr</u> <u>11-06-01</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 11:51:46 AM

Page 1

Work Order ID: 69475

Parent Item: D4164-041

Parent Item Name: Nut Plate Adapter Assembly




Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-09-07 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040  6061-T6 .040 Sheet		Purchased	No			100	sf	108.0000	0.001	0.021053			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				108					
					113004			12		i13004			
					117653			96					
MS21059L3  Nut Plate		Purchased	No				Each	134.0000		20			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST301				128					
					117423			28					
					117505			100		21			
				ST302				6					
					116706			6					
MS20426AD3-3  Rivet		Purchased	No				Each	2,755.000		40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				2755					
					19099			2755		118			

1811-5/18

60

i13004

EB 11/06/01

M117887
38x

EB 11/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	P/O D4164-041 KJ	

Dart Aerospace Ltd

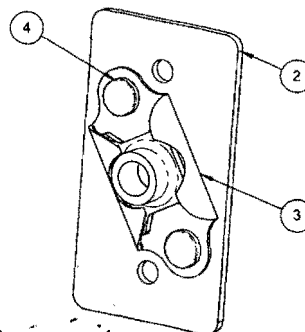
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4164-041	NUT PLATE ADAPTER ASSEMBLY
2	1	D4164-1	NUT PLATE ADAPTER
3	1	MS21059L3	NUT PLATE
4	2	MS20426AD3-3	RIVET



D4164-041 NUT PLATE ADAPTER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4164-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.006 lbs

SUBMITTED BY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 69475

11-05-11

RELEASED
 2010-09-07

A	NEW ISSUE	RF	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	KB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR	<i>[Signature]</i>	D4164	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	NUT PLATE ADAPTER ASSY	NTS
DATE	10.07.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

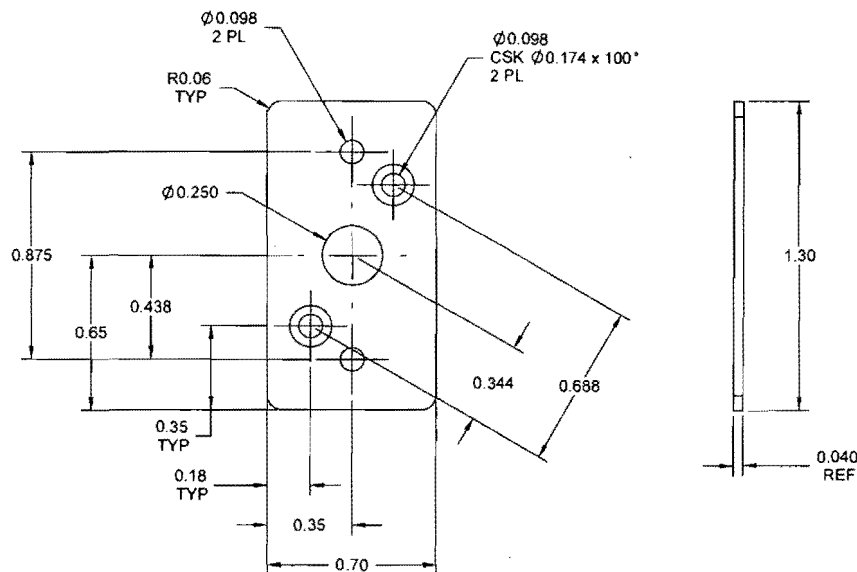
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4164-1 NUT PLATE ADAPTER

NOTES:

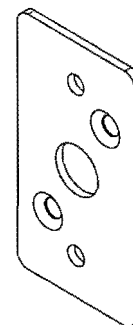
- 1) MATERIAL: 6061T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
PER DART SPEC. M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

DESIGN	KB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4164	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	NUT PLATE ADAPTER ASSY	
DATE	10.07.22	NTS	

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2010-09-07
[Signature]

W0649475



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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